

Work Order ID 148393

Tuesday, June 28, 2016 10:10:24 AM

148393

Page 1

Item ID: D412-783-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Gross Weight Towing Cable

Start Date: 6/10/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/1/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: A

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3943	E
IIN-D412-783	D

100 Document Control

JUL 28 2016

0.00

DAS
6
9-89

DAS
21
9-89
160802
②

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPPD412-783-011 CHG 005

2X
DAS
27
9-89

AUG 02 2016

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

② JC

DAS
28
9-89
AUG 02 2016
AUG 20 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Work Order ID 148393

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148393

Page 2

Item ID: D412-783-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Gross Weight Towing Cable

Start Date: 6/10/2016 Start Qty: 2.00

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Cust Item ID:

Required Date: 7/1/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.01

Quality Control

ENSURE CALIBRATION CERT. IS IN IIN PAPER WORK

X2

DAS
27
9-89

AUG 02 2016

130

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-783-011

Location: FG129

PPP Rev:

1X sold
1X fs/09

2

DAS
27
9-89

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.03

Quality Control

X2

DAS
28
9-89

DAS
21
9-89

AUG 02 2016

AUG 03 2016

2m 16/08/02

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 1

Work Order ID: 148393

148393

Parent Item: D412-783-011

D412-783-011

Parent Item Name: Gross Weight Towing Cable

Start Date: 6/10/2016

Required Date: 7/1/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 09-06-02 JLM Verified By:EC IPP Rev:B
@ chg 002 DD 10.02.22 Verified By:EC IPP Rev:C @ chg 004
DD 11.08.15 DD verf:JLM IPP Rev:D @ chg 005 DD 15.08.25
DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status												
D3943-041 *D3943-041* Ground Handlling Crank Assembly		Manufactured	No			110	Each	0.0000	1 **	2			DAS 28 9-89 B146TD												
D3951-041 *D3951-041* Equipment Bag Assembly		Manufactured	No			110	Each	0.0000	1 **	2															
D3954-1 *D3954-1* Gwt Pin		Manufactured	No			110	Each	35.0000	2 **	4			PC DAS 28 9-89												
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST063</td><td>35</td><td></td></tr><tr><td>102473</td><td>3</td><td></td></tr><tr><td>144636</td><td>32</td><td></td></tr></table>														Location	Loc Qty	Loc Code	ST063	35		102473	3		144636	32	
Location	Loc Qty	Loc Code																							
ST063	35																								
102473	3																								
144636	32																								
D3954-3 *D3954-3* Gwt Knob		Manufactured	No			110	Each	0.0000	2 **	4			DAS 28 9-89 PC 146790												
D3949-043 *D3949-043* Gross Weight Towing Cable Flag Assembly		Manufactured	No			110	Each	12.0000	1 **	2 B146790			PC DAS 28 9-89												

DAS
27
9-89

Location	Loc Qty	Loc Code
ST512	12	
137428	2	
142001	10	

AUG 02 2016

DQA: _____ Date: _____

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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

REFERENCE ONLY

4.0 CALIBRATION

4.1 Calibration of the D3943-041 Tow Crank Assembly

4.1.1 The chain ratchet handle on the D3943-041 Tow Crank Assembly must be calibrated annually to ensure the handle indicates "clicks" when a 3500 lbs – 4000 lbs load has been achieved. To calibrate loosen setscrew that locks the threaded stainless steel ball plunger (Refer to figure 2 for details). Place a load cell inline and ratchet until the 3500 lbs – 4000 lbs has been reached. If the handle clicks before the 3500lbs load then turn plunger clockwise 1/8 turn, remove load and retry. If handle does not click between the 3500lbs and 4000 lbs load, turn plunger 1/8 turn counterclockwise, remove load and retry. Once the handle has been properly set retighten setscrew and test once more.

4.1.2 The Tow Crank Assembly may be returned to DART for calibration, at the operator's expense.

5.0 PARTS LIST

QTY -011	PART NUMBER	DESCRIPTION
X	D412-783-011	GROSS WEIGHT TOWING KIT
1	D3943-041	TOW CRANK ASSEMBLY
1	D3949-043	FLAG ASSEMBLY
1	D3951-041	EQUIPMENT BAG
2	D3954-1	GWT PIN
2	D3954-3	GWT KNOB